



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4885-1

Job Sheet 183763



Part No: D4885-1

Job Qty: 12 ea

Part Name: End Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No:

Due Date: 10/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE JLM 14-01-28 VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	12 pcs		10/9/18	0.00	0.00	Purchasing		NOV 01 2018
110	QC	12 pcs		10/9/18	0.00	0.00	QC6		38
150	Outsource	12 pcs		10/9/18			SKY002-VC		NOV 07 2018
160	Packaging	12 pcs		10/9/18	0.00	0.00	Packaging2		38
170	QC	12 pcs		10/9/18	0.00	0.00	QC5		38
180	Packaging	12 pcs		10/9/18	0.00	0.00	Packaging3-2		38
190	QC21-SA	12 Ea		10/9/18	0.00	0.00	QC21		NOV 09 2018

Part Op 100 - ISSUE P/O: 041471 POSSIBLE SUPPLIER:ATG C OF C IS REQUIRED
Descriptions: 110 - QC6- All purchased or subcontracted products
150 - Issue P/O: 0458 LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required
160 - Receive & Inspect for Damage & Mat'l Certs Ensure certificate of conformity is attached
170 - QC5- Inspect part completeness to step on W/O
180 - Identify as per dwg & Stock Location:
190 - QC21- Final Inspection - Work Order Release

OCT 25, 2018 x 6 Rh

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4885-1P	End Fitting	12 pcs (1 ea)	100-Purchasing	5123780
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	4.8000 ft (4 ea)	100-Purchasing	5120117 PL
		4.300		5123781

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D4885-1P	12	0	0
	M17-4-H900-R2.000	5	9	0

Part Specifications

Specifications could not be found.

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S123782



Part: D4885-1
Job No: 183763
Serial No/Batch: S123782

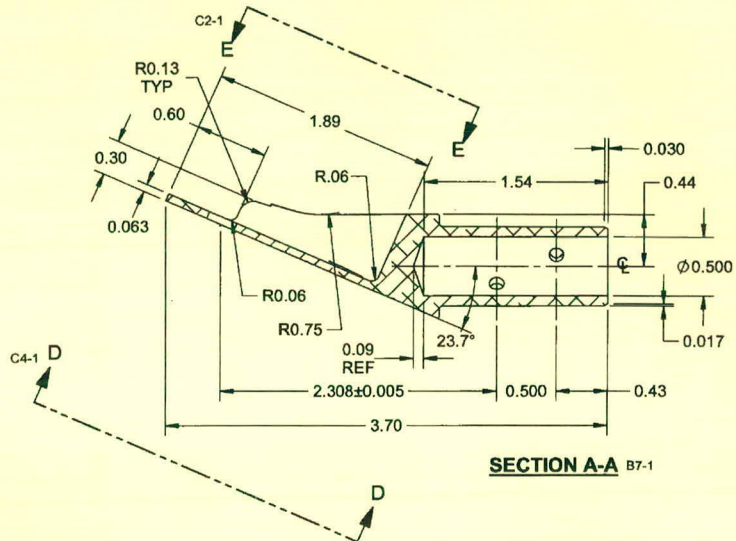
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: _____

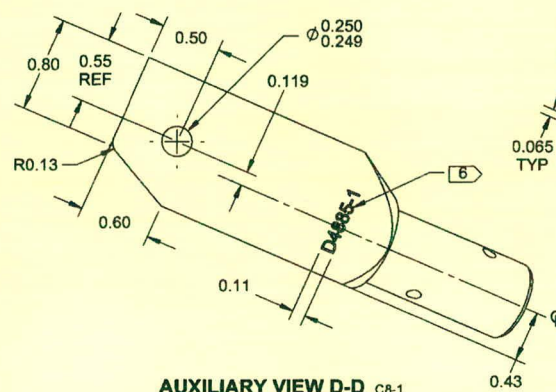
WORK ORDER NON-CONFORMANCE / UPDATE



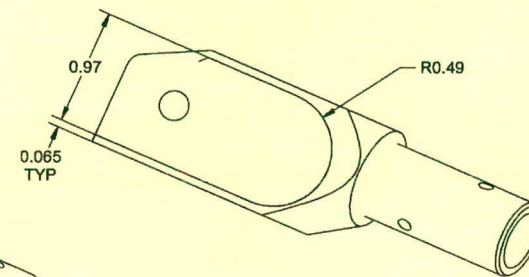
e: _____		Work Order update only ☐			
Date: 11/01/18	DISPOSITION		AGAINST DEPARTMENT/PROCESS		
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Step #:		QTY Effective :		MRB (QS1042) Approval	
Disposition Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				



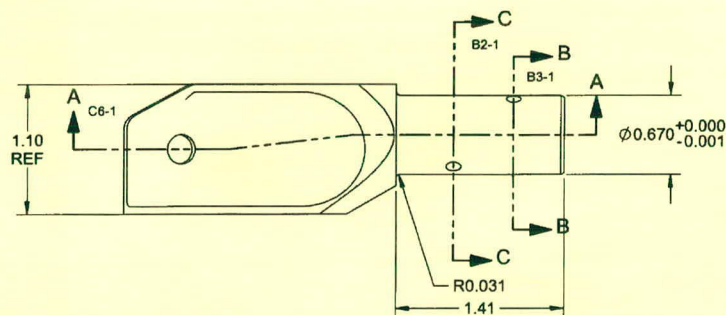
SECTION A-A B7-1



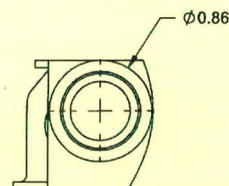
AUXILIARY VIEW D-D C8-1



AUXILIARY VIEW E-E D7-1



SECTION B-B B6-1



SECTION C-C B6-1

D4885-1 END FITTING

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.21 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4885	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END FITTING	NTS
DATE	13.12.01		

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041471**

Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO041471
PO Date: 10/25/18
Due Date: 11/1/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183763	D4885-1P			End Fitting : Various STC's receive pcs	Firmed	-	11/1/18	6 pcs	0 pcs	6 pcs	\$638.00/pcs	\$3,828.00
2	185408	D4885-1P			End Fitting : Various STC's receive pcs	Firmed	-	12/20/18	6 pcs	0 pcs	6 pcs	\$638.00/pcs	\$3,828.00

Grand Total: \$7,656.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 10/25/18 2:25 PM dart.Lussier.Patrick



Packing Slip 39311

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

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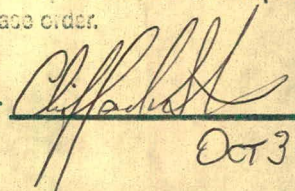
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

Attn: Robert Aboud - Dir

INVOICE DATE		YOUR ORDER NO. 041471		DATE ORDERED 10/25/18		SHIPPED VIA Best way	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
6	0	6	End fitting as per drawing D4885-1P Job number: 183763 Required by: November 1, 2018				
6	6	0	End fitting as per drawing D4885-1P Job number: 185408 Required by: December 20, 2018				
RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor  WMP 03 Oct 30/18 H.S.T.							

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL
NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
 TEL: 613-384-1882 FAX: 613-384-2887
 www.wejay.com

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INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA	
CUSTOMER CODE		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED	QUANTITY SUPPLIED	DESCRIPTION	UNIT PRICE	AMOUNT			
RELEASE NOTE I certify that the above listed items have been inspected and tested and conform to the specifications and requirements of the contract or purchase order. Inspection Supervisor: <i>[Signature]</i> Stamp: <i>[Circular Stamp with 'WMP' and '03']</i>							
TOTAL		ORDER COMPLETE ☐ PARTIAL ☐		NO GOODS RETURNED WITHOUT PRIOR AUTHORIZATION			

RECEIVED BY _____
 1.5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace	DATE: Oct. 30, 2018
	P.O.# 41471 line 1
	WEJAY JOB# 39311

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4885-1P 'End Fitting' Job: 183763	6	Machined complete per dwg req'ts.	D4885 / rev. A

Note: 1) Material supplied by DART. ref# not provided.
2) 1st article Inspection report attached.

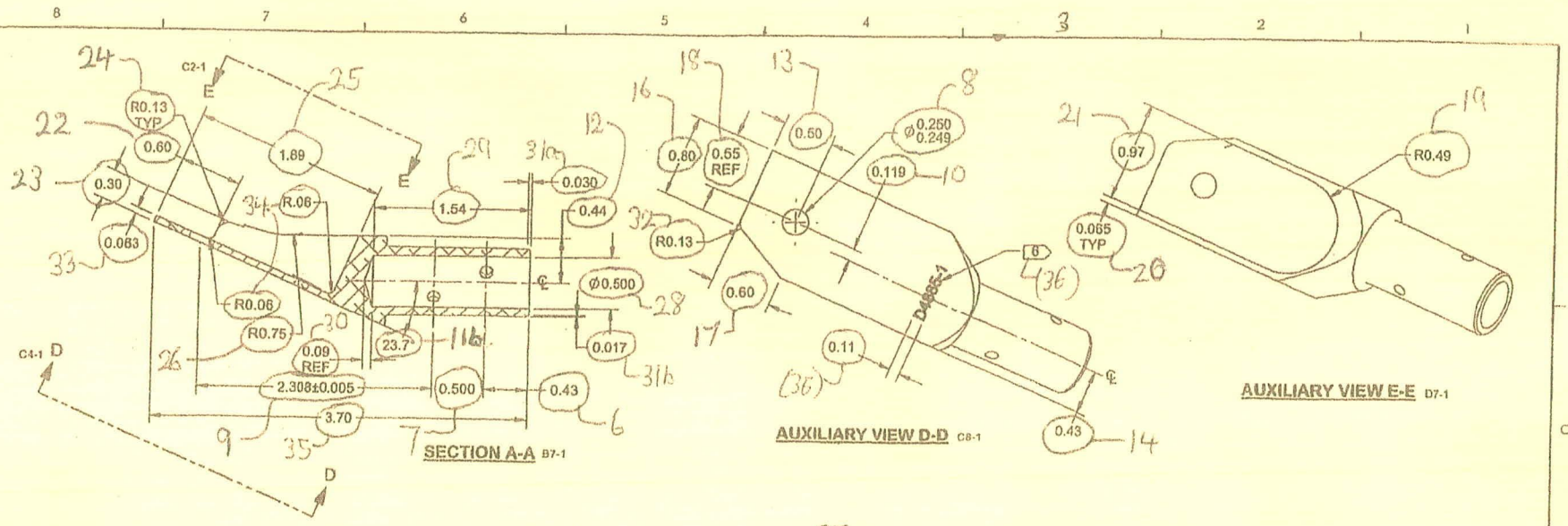
Records of Inspection/Test will be retained for 5 years minimum.

DAS
38
9-89

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



- NOTES:**
- 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION
PER AMS 5843/ASTM A564
DART SPEC M17-4-R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
 - 7) WEIGHT: 0.21 lbs
 - 8) LIQUID PENETRANT INSPECT PER QSI 035 6.1.1 (ASTM E1417 LEVEL 2)

D4885-1 END FITTING

SECTION B-B B6-1

SECTION C-C B6-1

A		NEW ISSUE		RF	13.09.10
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	RF			SHEET 1 OF 5	
CHECKED	DC	DRAWING NO. D4885		SCALE	
MFG. APPR.	JLM	TITLE		NTS	
APPROVED	HS	END FITTING			
DE APPR.	DS				
DATE	13.12.01				

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Customer DART Customer P.O. 41471
 Drawing # D4885 Drawing rev A
 Part Number D4885 E.C.O. -
 Part Name End Fitting Material 17-4 PH/S17400/TYPE 630 SS COND. H900
 Serial # 39261-009 Inspected by Cliff Smith
 Job # 39311 Signature:



Overall Result

All Characteristics: 37
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: Final Dim Insp.
 Material supplied by DART
 ref. # not provided

1ST ARTICLE

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- ->
1 B5 .670 dia	D	0.6697	0.6700	0.0000	-0.0010	-0.0003	-
2 B3 .125 dia hole 1	D	0.1249	0.1250	0.0040	-0.0010	-0.0001	—
3 B3 23.5 deg angle	A1	23.5589	23.7000	0.5000	-0.5000	-0.1411	—
hole 1 Perp to .670 dia	GDT Perp	0.0000	0.0000	0.0010		0.0000	-
Hole 1_GDT Symmetry to .670 dia	GDT Sym	0.0001	0.0000	0.0050		0.0001	-
4 B2 .125 dia hole 2	D	0.1249	0.1250	0.0040	-0.0010	-0.0001	—
5 B2 36.5 deg angle	A1	-36.4636	-36.4667	0.5000	-0.5000	0.0031	-
hole 2 Perp to .670 dia	GDT Perp	0.0000	0.0000	0.0010		0.0000	-
Hole 2_GDT Symmetry to .670 dia	GDT Sym	0.0001	0.0000	0.0050		0.0001	-
6 C5 .43 dim	X	-0.4227	-0.4300	0.0300	-0.0300	0.0073	-
7 C6 .500 hole pitch	ResEle	0.4999	0.5000	0.0100	-0.0100	-0.0001	—
8 D4 .250_.249 dia	D	0.2492	0.2500	0.0000	-0.0010	-0.0008	—
9 C7 2.308 dim	ResEle	-2.3093	-2.3080	0.0050	-0.0050	-0.0013	—
10 D4 .119 dim_.250 hole	X	-0.1200	-0.1190	0.0100	-0.0100	-0.0010	—
11a B6 1.41 dim	X	-1.4103	-1.4100	0.0300	-0.0300	-0.0003	—
11b C6 23.7 deg angle	A1	23.7437	23.7443	0.5000	-0.5000	-0.0006	—
12 D5 .44 dim	Z	0.4391	0.4400	0.0300	-0.0300	-0.0009	—
13 D4 .50 dim	CartDist	0.4998	0.5000	0.0300	-0.0300	-0.0002	—
14 C3 .43 dim	Y	0.4305	0.4300	0.0300	-0.0300	0.0005	-
15 B8 1.10 dim	CartDist	1.0999	1.1000	0.0300	-0.0300	-0.0001	—
16 D5 .80 dim	Y	0.7999	0.8000	0.0300	-0.0300	-0.0001	—
17 C5 .60 dim	X	0.6004	0.6000	0.0300	-0.0300	0.0004	-
18 D5 .55 ref dim	CartDist	0.5498	0.5500	0.0300	-0.0300	-0.0002	—
19 D1 .49 rad	R	0.4849	0.4900	0.0300	-0.0300	-0.0051	—
20 D3 .065 Wall Thk	CartDist	0.0646	0.0650	0.0100	-0.0100	-0.0004	—
21 D3 .97dim	CartDist	0.9703	0.9700	0.0100	-0.0100	0.0003	-
22 D8 .60 dim	X	0.6007	0.6000	0.0300	-0.0300	0.0007	-
23 D8 .30 dim	CartDist	0.2869	0.3000	0.0300	-0.0300	-0.0131	—
24 D8 .13 rad	R	0.1251	0.1300	0.0300	-0.0300	-0.0049	—
25 D7 1.89 dim	X	1.8960	1.8900	0.0300	-0.0300	0.0060	-
26 C7 .75 rad	R	0.7555	0.7500	0.0300	-0.0300	0.0055	-
27 B4 .86 dia	D	0.8599	0.8600	0.0300	-0.0300	-0.0001	—

Measurement Plan D4885 rev. A

Date October 9, 2018 2

Part Number D4885

Serial # 39261-009

Time 9:48:54 am



Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
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Manually Inspected Features

28	D5	.500 dia bore					<u>Ø.502</u>
29	D6	1.54 bore depth					<u>1.537</u>
30	C7	.09 rel. drill point					<u>-.085</u>
31	C5,D5	.017 x .030 chamfer					<u>-.017x30°</u>
32	D5	R .13 fillet 2 pl.					<u>R.1304P</u>
33	D8	.063 wall thickness					<u>-.062-.063</u>
34	D7	R 0.06 fillet					<u>R.060</u>
35	C7	3.70 O.A. length					<u>3.687</u>
36	A8,C3	Engraving per note 6					<u>PASSED</u>
37	A8	Deburring per note 5					<u>PASSED</u>
38	B6	R .031					<u>R.030</u>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041545**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041545
PO Date: 11/1/18
Due Date: 11/9/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	OH182881	SWA25A-3-OH	Electric Swivel 25,000 lb Safe Work Load (11,340 Kg) NDT -Issue P/O to Skyservice: P/O Magnaflux parts as per dwg C of C is required	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$27.8125/pcs	\$27.81
2	183763	D4885-1	End Fitting : Various STC's Issue P/O: LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required	Firmed	-	11/9/18	6 pcs	0 pcs	6 pcs	\$27.8125/pcs	\$166.88
3	184456	D4883-3	End Fitting : Various STC's Issue P/O: Certificate of conformaty is required.	Firmed	-	11/9/18	4 pcs	0 pcs	4 pcs	\$27.8125/pcs	\$111.25
4	183454	D4883-5	End Fitting : Various STC's Issue P/O:	Firmed	-	11/9/18	5 pcs	0 pcs	5 pcs	\$27.8125/pcs	\$139.06
Grand Total:										\$445.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041545

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/7/18 2:17 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38045	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041545 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON :

- 1 ELECTRIC SWIVEL (6 PCS), P/N# SWA25A-3 OH, J/S# OH182881,
6 END FITTINGS, P/N# D4885-1, J/S# 183763 ✓
4 END FITTINGS, P/N# D4883-3, J/S# 184456 ✓
5 END FITTINGS, P/N# D4883-5, J/S# 183454 ✓

Action Taken:						Date:	Initial/Stamp:
LPI & MPI C/O IAW ASTM E-1417 AND E-1444 REV. 16							
NO CRACK FOUND							
MAGBENCH S/N 208123 CAL DUE: 5-APR-2019 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO20165 PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142						NOV 05 2018	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: NOV 05 2018
Name: RAFIK MELIKIAN		

